

Date: Monday, 27/04/2009 7:13:00 AM  
 User: Jean-Luc Menard

## Process Sheet

|                       |   |                  |                               |
|-----------------------|---|------------------|-------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services             | Drawing Name     | : SPACER                      |
| Job Number            | : 47476   |                  |                               |
| Estimate Number       | : 13883   |                  |                               |
| P.O. Number           | :   | Part Number      | : D39031                      |
| This Issue            | : 27/04/2009 S.O. No. :                           | Drawing Number   | : D3903 PREL                  |
| Prsht Rev.            | : NC  | Project Number   | : N/A                         |
| First Issue           | : / /   | Drawing Revision | : PREL                        |
| Previous Run          | :   | Material         | :                             |
| Written By            | : <u>09.04.27</u>                                 | Due Date         | : 04/05/2009 Qty: 26 Um: Each |
| Checked & Approved By | :   |                  |                               |
| Comment               | : Est Rev:A New Issue 09-04-24 JLM Verified By:EC |                  |                               |

Additional Product

PRELIMINARY ISSUE



Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                  |                             |
|-----|------------------|-----------------------------|
| 1.0 | M6061T6T0375W058 | 6061-T6 RD Tube .375 x.058W |
|-----|------------------|-----------------------------|



CERTIFICATE OF CONFORMITY  
REQUIRED



Comment: Qty.: 0.3623 f(s)/Unit Total: 9.4185 f(s)  
 6061-T6 RD Tube .375 x.058W  
 BATCH: M11432

SA 09/05/10

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA813 & DWG D3903,  
 FOLIO REV: N/A  
 DWG REV: PREL

2-DEBURR AS REQUIRED

SA 09/05/10

(34)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/05/10

(34)

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



ENGINEERING  
APPROVAL



Comment: SECOND CHECK

ml / PH 09.05.12

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock in Skidtube cell

Location: Skid tube welding booth

CT 09 05 27

(34)

STORE IN ENG'G SHED  
ENG USE ONLY

PH 09.09.02

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 47476

Part Number: D39031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-23

POSITIVE RECALL

EFFECTIVE 90427 AUTH 9

RELEASED 14 DATE 09.09.02

ENG USE ONLY

SCRAP REMINDER

909.09.02

|  |                     |                    |
|--|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>                      | <b>Work Order:</b>  | 47476              |
| <b>Description:</b> Space1                     | <b>Part Number:</b> | 3903-1             |
| <b>Inspection Dwg:</b> 3903-1 <b>Rev:</b> PREL |                     | <b>Page 1 of 1</b> |

|             |       |
|-------------|-------|
| Work Order: | 47476 |
|-------------|-------|

**Description:** *Mac P1*

|              |       |
|--------------|-------|
| Part Number: | 3903- |
|--------------|-------|

Inspection Dwg: 3903-1 Rev: PREL

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

[illegible]

## Tolerance

**Actual  
Dimension**

**Accept**

## Reject

## Method of Inspection

## Comments

4,080

1. 000

4.085

0.375

7.006  
7.001

0.3 K

0.257

4.006  
-001

0.259

✓

030x45°

 $\tau_{-0/c}$ 

-030x45<sup>2</sup>

✓

Date: 09/05/10

**Audited by:**

**Date:** 09/05/11

### Prototype Approval:

**Date:** 09.05.12

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |

Date \_\_\_\_\_

## Change

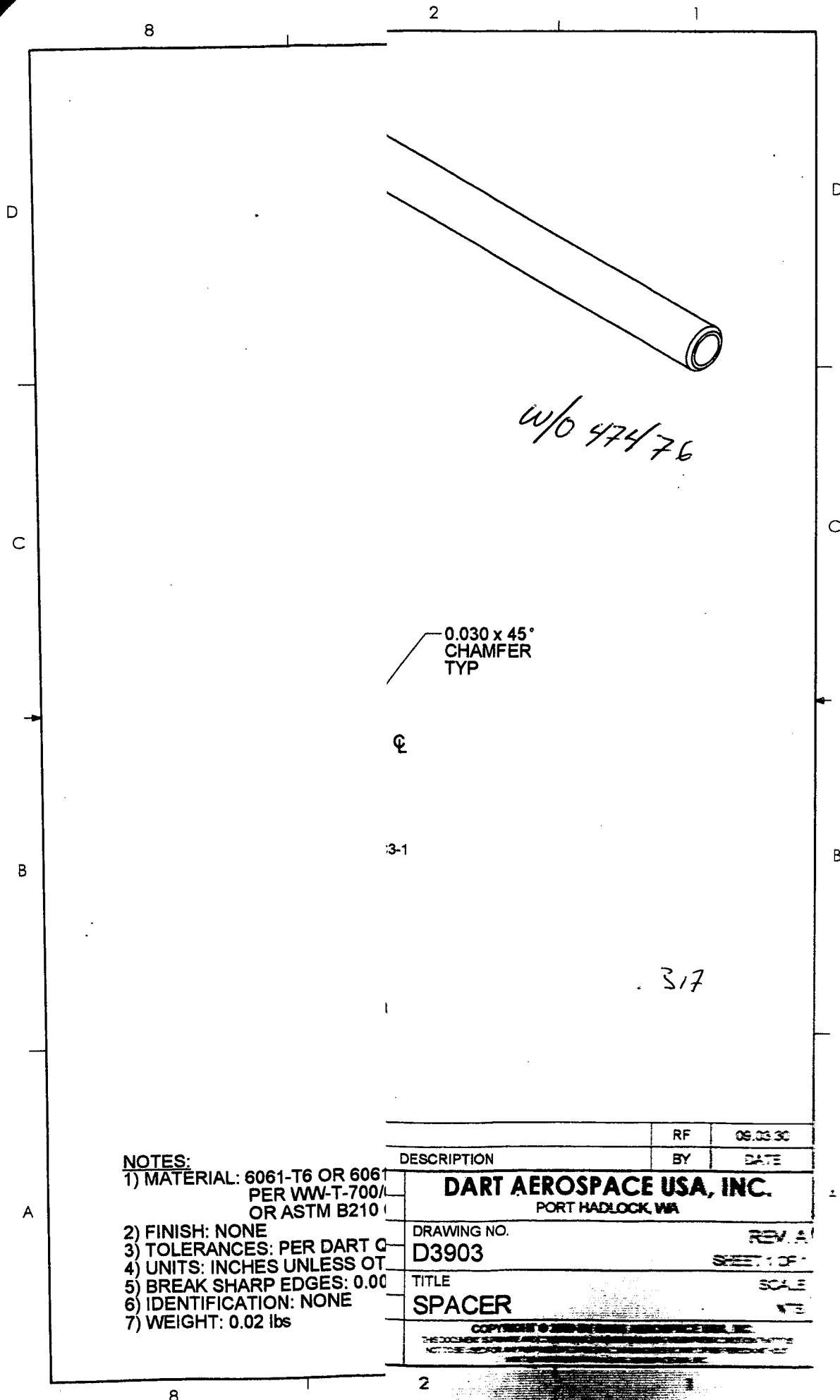
Revised by

**Approved**

**A**

## New Issue

**KJ/JLM**



w/o 47476

0.030 x 45°  
CHAMFER  
TYP

Q

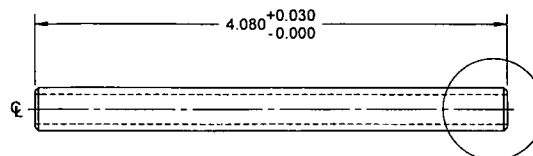
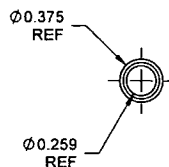
3-1

317

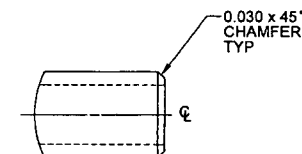
**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061  
PER WW-T-700/  
OR ASTM B210
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART Q
- 4) UNITS: INCHES UNLESS OT
- 5) BREAK SHARP EDGES: 0.00
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

|  |              |          |
|--|--------------|----------|
|  | RF           | 09.03.30 |
| DESCRIPTION  | BY           | DATE     |
| <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, MA  |              |          |
| DRAWING NO.  | REV. A       |          |
| D3903  | SHEET 1 OF 1 |          |
| TITLE  | SCALE        |          |
| SPACER   | N/A          |          |
| <small>COPYRIGHT © 2000 DART AEROSPACE USA, INC.<br/>         THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED TO THE<br/>         PUBLIC OR FORN DISSEMINTATION WITHOUT THE<br/>         AUTHORIZATION OF THE DART AEROSPACE USA, INC.</small> |              |          |



B2-1  
DETAIL A



DETAIL A C3-1  
SCALE 2X

**D3903-1 SPACER**

47476

RELEASED  
10/6/54

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM SEAMLESS TUBING 0.375" OD x 0.058" WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
OR ASTM B210 OR ASTM B241 (REF DART SPEC. M6061T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

|            |  |   |              |
|------------|--|---|--------------|
| B          | CORRECT TYPO Ø0.375 WAS Ø0.313 (ZN A6-1) | RF  | 09.06.30     |
| A          | NEW ISSUE                                | RF  | 09.03.30     |
| REV.       | DESCRIPTION                              | BY  | DATE         |
| DESIGN     | RF                                       | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA   |              |
| DRAWN      | RF                                       |   |              |
| CHECKED    | RF                                       | DRAWING NO.   | REV. B       |
| MFG. APPR. | RF                                       | D3903   | SHEET 1 OF 1 |
| APPROVED   | RF                                       | TITLE   | SCALE        |
| DE APPR.   | RF                                       | SPACER  | NTS          |
| DATE       | 09.06.30                                 | <small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |              |